



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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SWA3-100
Job Sheet 189363



Part No: SWA3-100

Job Qty: 5 pcs *6* *DAC*
21
8-88

Part Name: Upper End - Swa3 Swivel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/23/19

Job Tracking No:

Due Date: 2/22/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG SWA3-100 Rev 15 IPP Rev A 18.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	5 pcs	2/22/19	2/22/19	0.00	0.50	Bandsaw - 1		<i>[Signature]</i>
110	NLX 2500SY - B4B	5 pcs	2/22/19	2/22/19	0.00	5.00	NLX 2500SY - 1 - B4B		
120	QC 2	5 pcs	2/22/19	2/22/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		<i>[Signature]</i>
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Container No: S150016



Part: SWA3 - 100

Job No: 189363

Serial No/Batch: S150016

Revision: 15

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/31/19

Plex 1/23/19 9:23 AM Dart.lajeunesse.mari

130	QC 8	5 pcs	2/22/19	0.00 0.00	QC 2 - 8	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	A.E 19-02-20
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
140	Packaging 3-1 - Stock - B4B	5 pcs	2/22/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	0-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
150	QC 21 - SA	5 pcs	2/22/19	0.00 0.00	QC 21 - SA - 21	

QC 21 - SA - 70

Part Op **100** - (Bandsaw) Cut Blanks to 6.250"

Descriptions: **110** - NLX (MORI NLX 2500SY LATHE) 1-Machine as per DWG. FC330 FOLIO REV: _____ DWG REV: _____
 2-Deburr ***Machine engrave S/N number and machine engrave UP arrow***

120 - (QC2- Inspect parts off machine FAI/FAIB)**130** - (QC8- Inspect parts - second check)**140** - (Identify as per dwg & Stock Location: _____)**150** - (QC21- Final Inspection - Work Order Release)**Job BOM**

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R2.000	17-4 SS Round Bar 2.000"	2.6000 ft (.52 ea)	100-Bandsaw - 1	5120116

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M17-4-H1150-R2.000	3	6	0

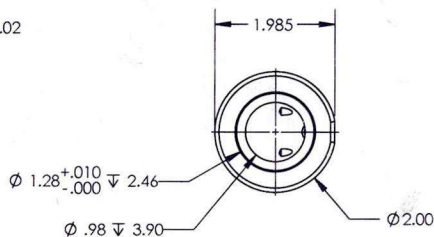
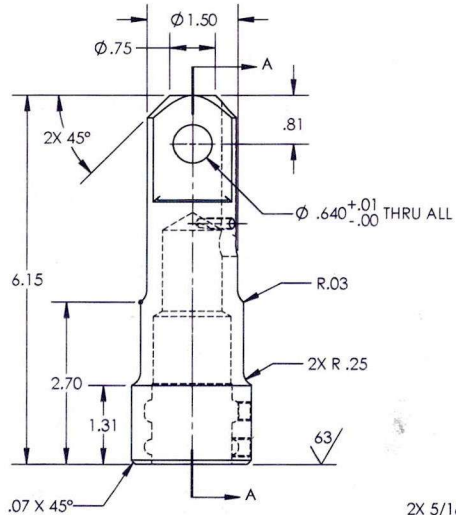
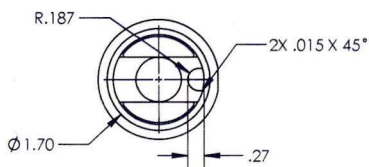
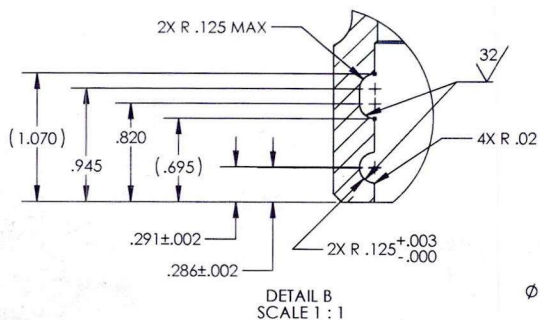
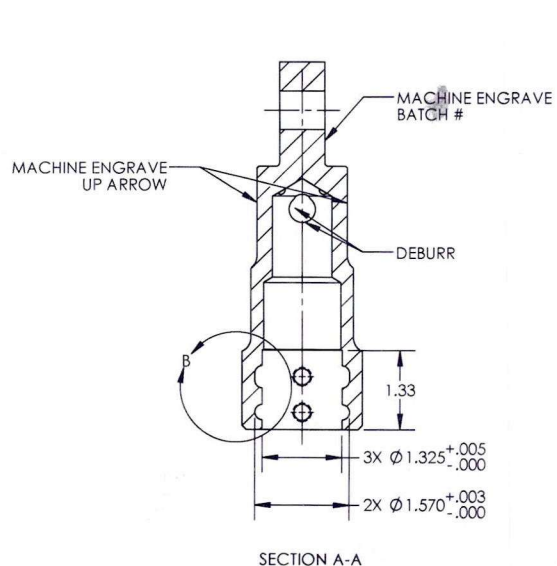
Part Specifications

Specifications could not be found.

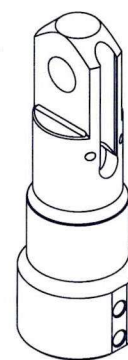
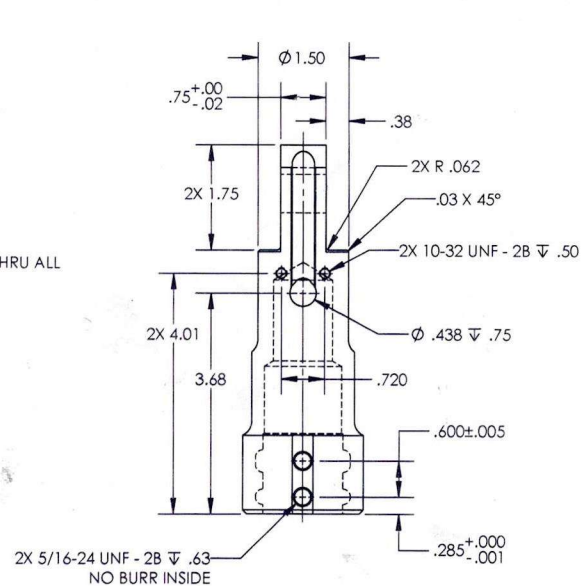
Plex 1/23/19 9:23 AM Dart.lajeunesse.marie

MAT
USED
3.145"

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
11		AS DRAWN BY CANAM	8/24/2012		
11A		CHD DIMENSIONS 1.070 & .495 TO REFERENCE. ADDED CENTER DIMENSIONS OF .945 & .820	11/15/2012	JAG	
12	15-0270	ADDED UP ARROW NOTE. CHD MATL WAS S5 17-4 PH IS S5 17-4, H1150/1075. CHD DIM WAS .75 IS .75 +.00 -.02.	9/22/2015	DPD	JAG
13	16-0083	CHD DIM WAS .375 IS .38, WAS .286 IS .286±.002, WAS .291 IS .291±.002, WAS Ø1.325±.005/-0.000 IS 3X Ø1.325±.005/-0.000, WAS Ø1.570±.003/-0.000 IS 2X Ø1.570±.003/-0.000.	7/18/2016	SM	JAG
14	17-0036	CHD DIMS WAS 1.75 IS 2X 1.75, WAS 2X 5/16-24 UNF-2B 2X 425 NO BURR INSIDE IS 2X 5/16-24 UNF-2B 2X 43 NO BURR INSIDE, WAS 4X R.015 IS 4X .02. ADDED NOTE MACHINE ENGRAVE BATCH #.	2/6/2017	RJC	JAG
15	17-0153	CHD DIM WAS Ø1.00 +.010/-0.000 3.90 IS Ø.98 3.90.	6/20/2017	RJC	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189367 405
19-01-23

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA3-100	1	UPPER END	S.S. 17-4, H1150/H1075	

DART AEROSPACE	
TITLE UPPER END SWA3 SWIVEL	
DWG NO. SWA3-100	REV 15
MATERIAL S.S. 17-4, H1150/H1075	
TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES ± 125	
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CANAM CHECKED: DUERFELDT OPFS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
SCALE 1:2	DATE 6/18/2002 SHEET 1 OF 1

1-4425
6-2116

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:	1893.63
Description: upper end SWA3 Swivel		Part Number:	SWA3-100
Inspection Dwg: SWA3-100	Rev: 15	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.33	$\pm .01$	1.335			Vern LPO9	
$\phi 1.325$	$\pm .005 / - .000$	1.3285			Mic LPO5	
$\phi 1.570$	$\pm .003 / - .000$	1.572			112-177	
R.187	$\pm .005$	.187			Rad gauge	
$.015 \times 45^\circ$	$\pm .005 \times .5^\circ$	$.015 \times 45^\circ$			Vern LPO9	
.27	$\pm .01$	.270				
$\phi 1.70$	$\pm .01$	1.700				
$\phi 1.50$	$\pm .01$	1.500				
$\phi .75$	$\pm .01$	.750				
45°	$\pm .5^\circ$	45°			Protractor	
6.15	$\pm .01$	6.155			Vern LPO10	
2.70	$\pm .01$	2.705				
1.31	$\pm .01$	1.316				
R.25	$\pm .01$	.250			Rad gauge	
R.03	$\pm .01$	.031				
$\phi .640$	$\pm .01 / - .000$	.6415			Mic LPO4	
.81	$\pm .01$	.8127			Mic LPO6	
1.985	$\pm .005$	1.980			Vern LPO9	
1.28	$\pm .01 / - .00$	1.285				
$\phi .98$	$\pm .01$	.980				
2.46	$\pm .01$	2.470				
3.90	$\pm .01$	3.895				
$\phi 2.00$	$\pm .01$	1.993				
$\phi 1.50$	$\pm .01$	1.500				
.75	$\pm .00 / - .02$	.739"			Mic LPO1	
1.75	$\pm .01$	1.755			Vern LPO9	
4.01	$\pm .01$	4.017			HG-	
3.68	$\pm .01$	3.683				
.285	$\pm .000 / .001$	.286			Mic LPO6	

Measured by: <i>[Signature]</i>	Checked by: <i>[Signature]</i>	QC Inspector:
Date: 19-02-05	Date: 19-02-20	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

